

# Work Order ID 86696

\*86696\*

Page 1

July-06-12 11:35:35 AM

Item ID: D3209-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bushing

Start Date: 7/06/12 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 12/07/12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3209

Rev A

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3209-3 bushing as per Folio FA354 and Dwg D3209

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86696

\*86696\*

Page 2

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Accept

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Start Date: 7/06/12

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

8/34

0.00

\*130\*

Packaging

Memo

0.00

Packaging

12-7-14

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

12/7/18

mf  
12-07-18

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 11:35:35 AM

Page 1

Work Order ID: 86696

Parent Item: D3209-3

Parent Item Name: Bushing

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A04.04.14New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No			100	f	261.7260	0.0333	0.4206312			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	261.726	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
121728	74.584	

1.052 mk 12/07/16

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# Dart Aerospace Ltd

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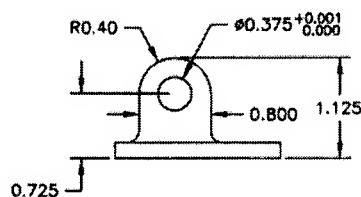
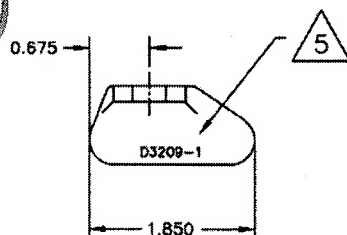
**NOTE:** Date & initial all entries





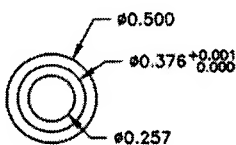
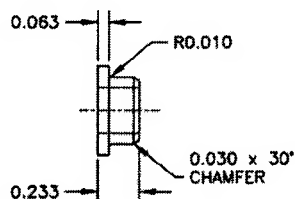
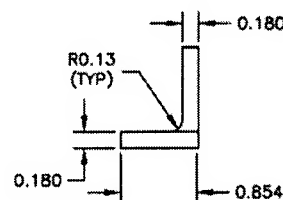
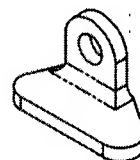
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05



2

**D3209-1 BRACKET**



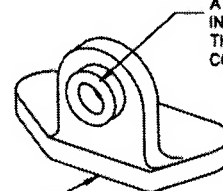
3

**D3209-3 BUSHING**  
SCALE 1:2

4

**D3209-041 ASSEMBLY**

D3209-3 BUSHING  
PRESS FIT, HEAD  
AT THIS FACE  
INSTALL AFTER  
THE CONVERSION  
COAT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86694

112075

**D3209-1 BRACKET: D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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**Dart Aerospace Ltd**

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